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D4634-143

Job Sheet 201703



Part No: D4634-143

Job Qty: 1 pcs

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/9/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4634 REV.H SHEET 8 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	11/15/19		0.00	1.47	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	11/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	11/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS 58
				Packaging 3 - 7 - B4B	58
				Packaging 3 - 8 - B4B	9-20-2019
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	11/15/19	0.00 0.00	QC 21 - SA - 21	DAS 21 NOV 20 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-20

Part Op 110 - Small Fab (Small Fab) Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: 3214697 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 5159491 Expiry Date 03/27/2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: m138861
 120 - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O
 130 - Packaging3 (Identify as per dwg & Stock Location: _____ Identify as per dwg & Stock Location: _____)
 140 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-03	Cherry Rivet	4 Ea (4 ea)	110-Small Fab - 1	5180315
D4634-3	Middle, Center Ceiling Panel	1 pcs (1 ea)	110-Small Fab - 1	5131085
D4636-5	Bracket	2 pcs (2 ea)	110-Small Fab - 1	5129441
D4647-1	Doubler	1 pcs (1 ea)	110-Small Fab - 1	5115182
D4664-5	Spacer	6 pcs (6 ea)	110-Small Fab - 1	5132125 x1
D4712-1	Bracket	2 pcs (2 ea)	110-Small Fab - 1	5226719
D4732-21	Label	1 pcs (1 ea)	110-Small Fab - 1	5060897
D4732-25	Label	1 pcs (1 ea)	110-Small Fab - 1	5060897
D5021-3	Foam, Center Panel, Middle	1 pcs (1 ea)	110-Small Fab - 1	5224246
MPNY-750S-9-C	Mounting Pad	3 pcs (3 ea)	110-Small Fab - 1	5130423-1
MS20426AD4-6	Rivet	4 Ea (4 ea)	110-Small Fab - 1	5216272
MS21059L08	Nut	2 Ea (2 ea)	110-Small Fab - 1	5140391

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	CCR264SS-3-03	4	176	0
	D4634-3	1	3	0
	D4636-5	2	41	0
	D4647-1	1	4	0
	D4664-5	6	7	0
	D4712-1	2	13	0
	D4732-21	1	13	0
	D4732-25	1	16	0
	D5021-3	1	13	0
	MPNY-750S-9-C	3	104	0
	MS20426AD4-6	4	873	0
	MS21059L08	2	139	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

MRB (Q51042)

Sequence #: _____

QTY Affected: _____

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: